

Work Order ID 86028

June-19-12 4:05:58 PM

86028

Page 1

Item ID: D4062-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Tank Support

Start Date: 19/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4062	C
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100		0.00							
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER FILE D4062-3

ultim w 250

dwg rev: *E*
prog rev: *E*

6 0 Jm 12-6-24

102	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

102

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-24

130	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

130

QC

Memo

0.00

Quality Control

6 N 12 6 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: *WA*

0.00

140

Packaging

Memo

0.00

Packaging

*lex**SD**12-6-25*

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

*12/6/26**mrf**12-06-25*

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:06:02 PM

Page 1

Work Order ID: 86028

86028

Parent Item: D4062-3

D4062-3

Parent Item Name: Lower Tank Support

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 11-11-28 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB250

Purchased

No

sf

59.0000

17.05263

MI IHMWB250

**

UHMWB 250 BLACK

Jan 12-6-24

Location

Loc Qty

Loc Code

MAT019

59

121064

59

121064

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86028
Description: Lower Tank Support		Part Number:	D4062-3
Inspection Dwg: D4062 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	0.998"	✓		✓	mm01
2.00	+/-0.030	1.996"	✓		✓	"
0.25	+/-0.030	0.257"	✓		✓	"
2.95	+/-0.030	2.950"	✓		✓	"
4.95	+/-0.030	4.965"	✓		✓	"
10.07	+/-0.030	10.081"	✓		✓	Prod W 502
15.39	+/-0.030	15.39"	✓		MT	mm01
20.71	+/-0.030	20.71"	✓		MT	"
26.18	+/-0.030	26.18"	✓		MT	"
28.18	+/-0.030	28.18"	✓		MT	"
31.13	+/-0.030	31.13"	✓		MT	"
0.38	+/-0.030	0.390"	✓		✓	mm01
1.38	+/-0.030	1.396"	✓		✓	"
11.96	+/-0.030	11.971"	✓		✓	Prod W 502
0.35	+/-0.030	0.354"	✓		✓	mm01
6.31	+/-0.030	6.310"	✓		✓	"
0.250	+/-0.010	0.250"	✓		✓	"

Measured by:	JM	Audited by:	WHL	Preliminary Approval:	
Date:	12-6-24	Date:	12-06-25	Date:	

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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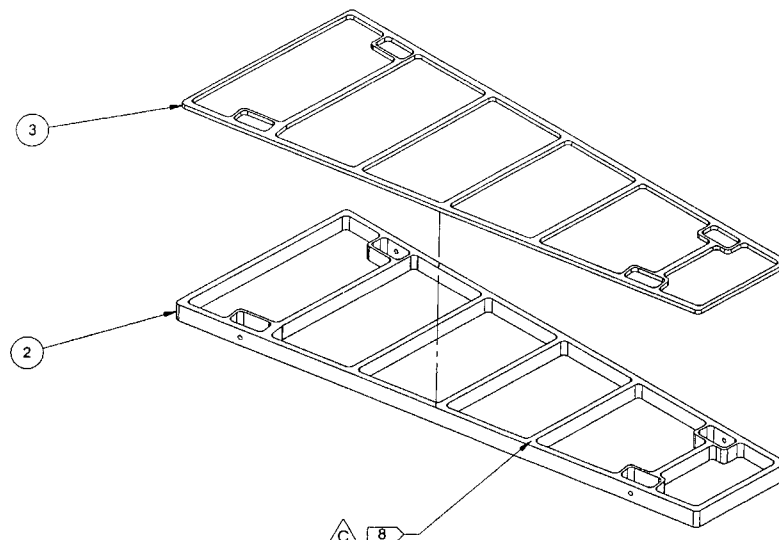
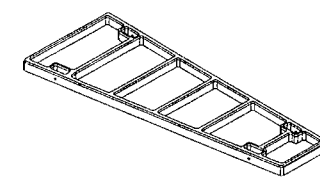
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



D4062-041 TANK SUPPORT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06628 MLJ
12/06/20

2012-03-02
JW

- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.91 lbs
8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C'BORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4062 REV. C SHEET 1 OF 3 TITLE TANK SUPPORT SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.12.14		

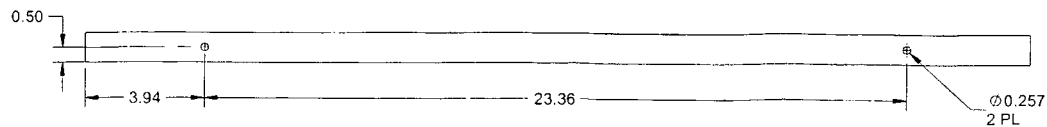
W/O:		WORK ORDER CHANGES					
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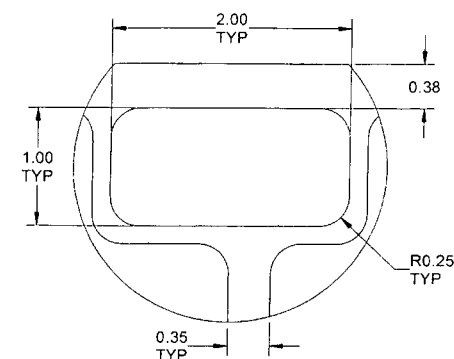
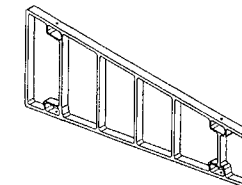
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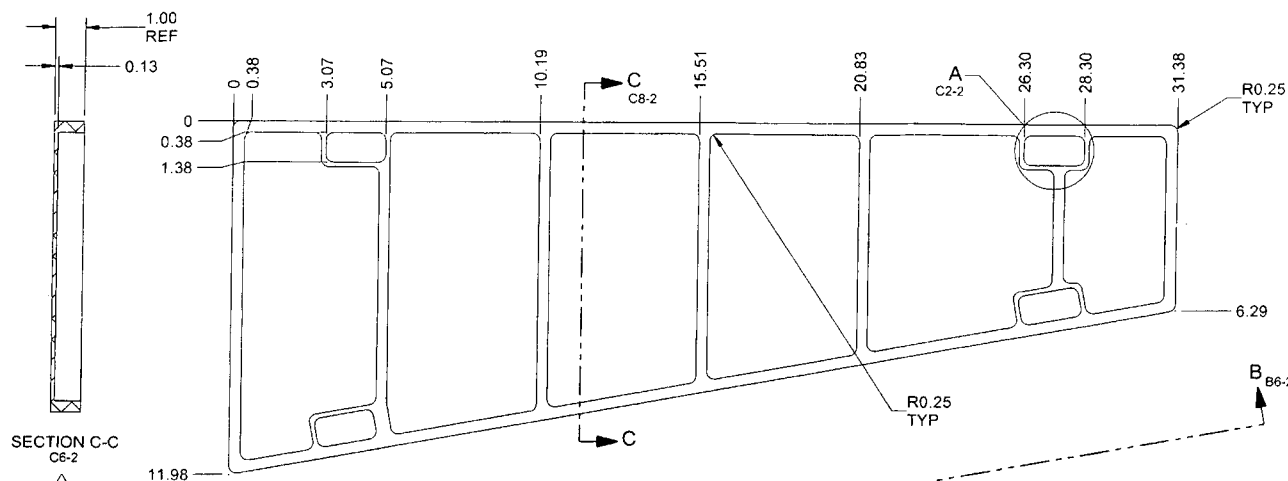
NOTE: Date & initial all entries



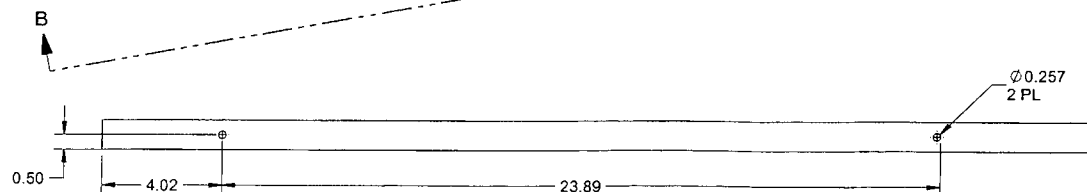
06028



DETAIL A
SCALE 4X
C4-2



SECTION C-C
C6-2
C



VIEW B-B
B5-2

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs
- 8) CUT PER D4062-1 DXF
- 9) MAXIMUM INSIDE RADIUS = 0.250

D4062-1 LOWER TANK SUPPORT

DESIGN	JE	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO. D4062	REV. C
MFG. APPR.	JE	SHEET 2 OF 3	
APPROVED	MA	TITLE	SCALE
DE APPR.	JE	TANK SUPPORT	NTS
DATE	11.12.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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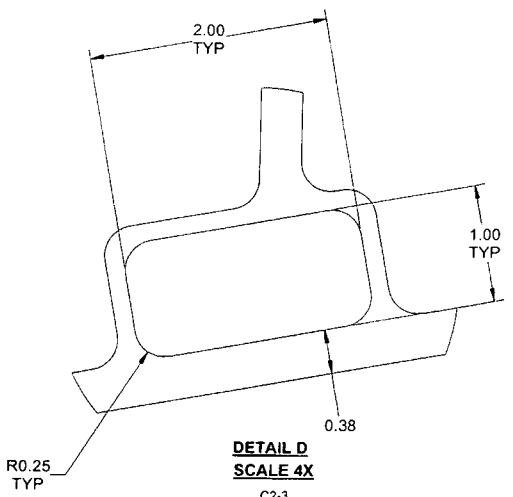
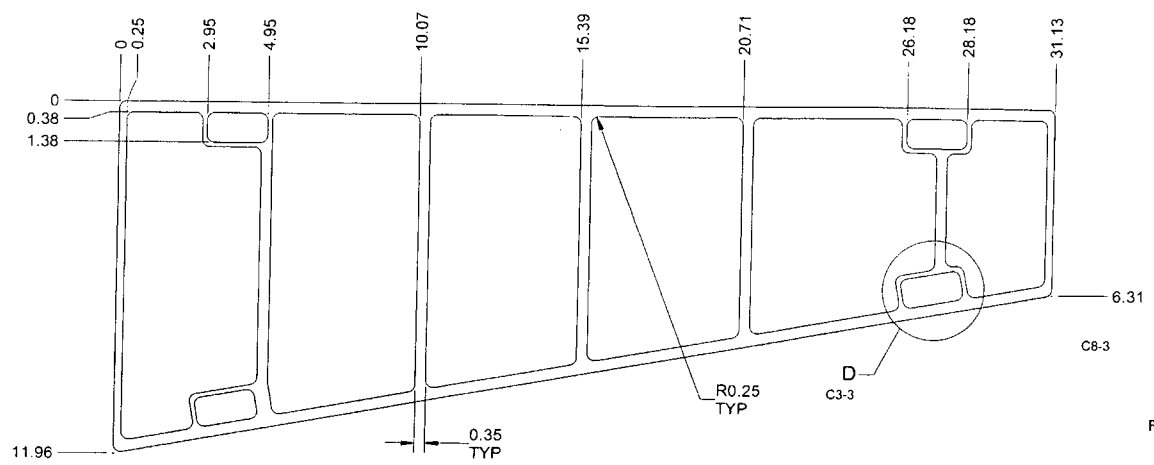
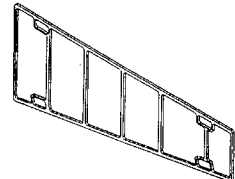
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NOTE: Date & initial all entries

86028



D4062-3 UPPER TANK SUPPORT

RELEASED
2012-03-02
MM

- NOTES:**
 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK
 REF DART SPEC MUHMB025
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.37 lbs
 8) CUT PER D4062-3.DXF

DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4062	SHEET 3 OF 3
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	TANK SUPPORT	NTS
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